

CLAIMS

1. An easy open end comprising a polyester resin film having about 5 minutes or shorter half crystallization time and about 0.04 or smaller plane orientation coefficient at thicknesses from about 10 to about 30 μ m on at least one side of a steel sheet, the easy open end being provided with a tear-off groove having a cross sectional shape with curvatures from about 0.1 to about 1 mm.

2. The easy open end as in claim 1, wherein the polyester resin is a polymer of ethylene glycol with at least one dicarboxylic acid selected from the group consisting of terephthalic acid and isophthalic acid.

3. The easy open end as in claim 1, wherein the polyester resin is a polymer of terephthalic acid with at least one glycol selected from the group consisting of ethylene glycol and butylene glycol.

4. The easy open end as in any one of claims 1-3, wherein the polyester resin is a copolyester.

5. The easy open end as in claim 1, wherein the polyester resin is a mixture of polyethylene terephthalate and polybutylene terephthalate.

6. The easy open end as in claim 1, wherein the polyester resin is a copolyester in which about 94 to about 98% by mole of a polybasic acid components is a terephthaloyl component.

7. The easy open end as in claim 2 or claim 6, wherein the polyester resin is a copolyester of terephthalic acid, isophthalic acid, and ethylene glycol.

8. A laminated steel sheet comprising a resin coating layer on each side of a steel sheet, being used for a lid requiring no can opener, (an easy open end), having a tear-off groove thereon formed by press-forming using a curved surface die to give a groove cross sectional shape with curvatures from 0.1 to 1.0 mm, the resin coating layer comprising a polyester resin having 5 minutes or shorter half crystallization time, 0.04 or smaller plane orientation coefficient, and 10 to 30 μ m of thickness.

9. A laminated steel sheet comprising a resin coating layer on each side of a steel sheet, being used for a lid requiring no can opener, having a tear-off groove thereon formed by press-forming using a curved surface die to give a groove cross sectional shape with curvatures from 0.1 to 1.0 mm, the resin coating layer being a copolyester resin comprising a dicarboxylic acid component and a glycol component, the dicarboxylic acid components containing terephthalic acid from 94% or more to less than 98% by mole, and the copolyester resin having 0.04 or smaller plane orientation coefficient and 10 to 30 μ m of thickness.